

# Work Order ID 83853

**\*83853\***

Page 1

April-26-12 2:22:12 PM

Item ID: D3235-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Mounting Lug

Start Date: 26/04/2012 Start Qty: 100.00

**\*100\***

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 100.00

**\*100\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/26

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3235

Rev A

100

0.00

**\*100\***

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.820"

Batch:

Cut @ meter

CL 12/04/30 100

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr

issue P/O to meter

machine as per dwg D3235 REV. A

CL 12/04/30 100

P/O: 16853

120

0.00

**\*120\***

QC2-Inspect parts off machine FAI/FAIB

QC rec'd

Memo

0.00

Quality Control

rec'd + inspect for transit damage,  
attached C of C to W/O

144/3 (100)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 83853

**\*83853\***

Page 2

April-26-12 2:22:12 PM

Item ID: D3235-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Mounting Lug

Start Date: 26/04/2012 Start Qty: 100.00

**\*100\***

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 100.00

**\*100\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

100

12-05-31

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

100

12-6-4

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*160\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:50  
3200 F  
12:20

100X

MT

12/06/07

12/11/34

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 83853

\*83853\*

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April-26-12 2:22:12 PM

Item ID: D3235-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Mounting Lug

Start Date: 26/04/2012 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

170 QC3- Inspect Part Finish 0.00

\*170\*

QC Memo 0.00

Quality Control

100 x 4 12/06/07  
COUNT

180 Identify as per dwg & Stock Location: 5-481 0.00

\*180\*

Packaging Memo 0.00

Packaging

100 Jack 12/06/08

190 QC21- Final Inspection - Work Order Release 0.00

\*190\*

QC Memo 0.00

Quality Control

12/06/11

MF 12-06-08

10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

April-26-12 2:22:16 PM

Page 1

Work Order ID: 83853

\*83853\*

Parent Item: D3235-1

\*D3235-1\*

Parent Item Name: Mounting Lug

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP A04.04.19New issueKJ/JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|          |  |           |    |  |  |     |      |          |   |     |  |  |  |
|----------|--|-----------|----|--|--|-----|------|----------|---|-----|--|--|--|
| D3235-1P |  | Purchased | No |  |  | 100 | Each | 100.0000 | 1 | 100 |  |  |  |
|----------|--|-----------|----|--|--|-----|------|----------|---|-----|--|--|--|

\*D3235-1P\*

lug

\*\*

4/25/12 (100)

Location

Loc Qty

Loc Code

ST 100

81970 100

|       |  |              |    |  |  |     |   |          |        |          |  |  |  |
|-------|--|--------------|----|--|--|-----|---|----------|--------|----------|--|--|--|
| D2423 |  | Manufactured | No |  |  | 110 | f | 549.5080 | 0.0683 | 7.189474 |  |  |  |
|-------|--|--------------|----|--|--|-----|---|----------|--------|----------|--|--|--|

\*D2423\*

Lug Extrusion

\*\*

CL 12/04/130

Location

Loc Qty

Loc Code

MAT006 549.508

43722 161.5

68331 84.008

81557 304

7.19

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No **DQA** Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

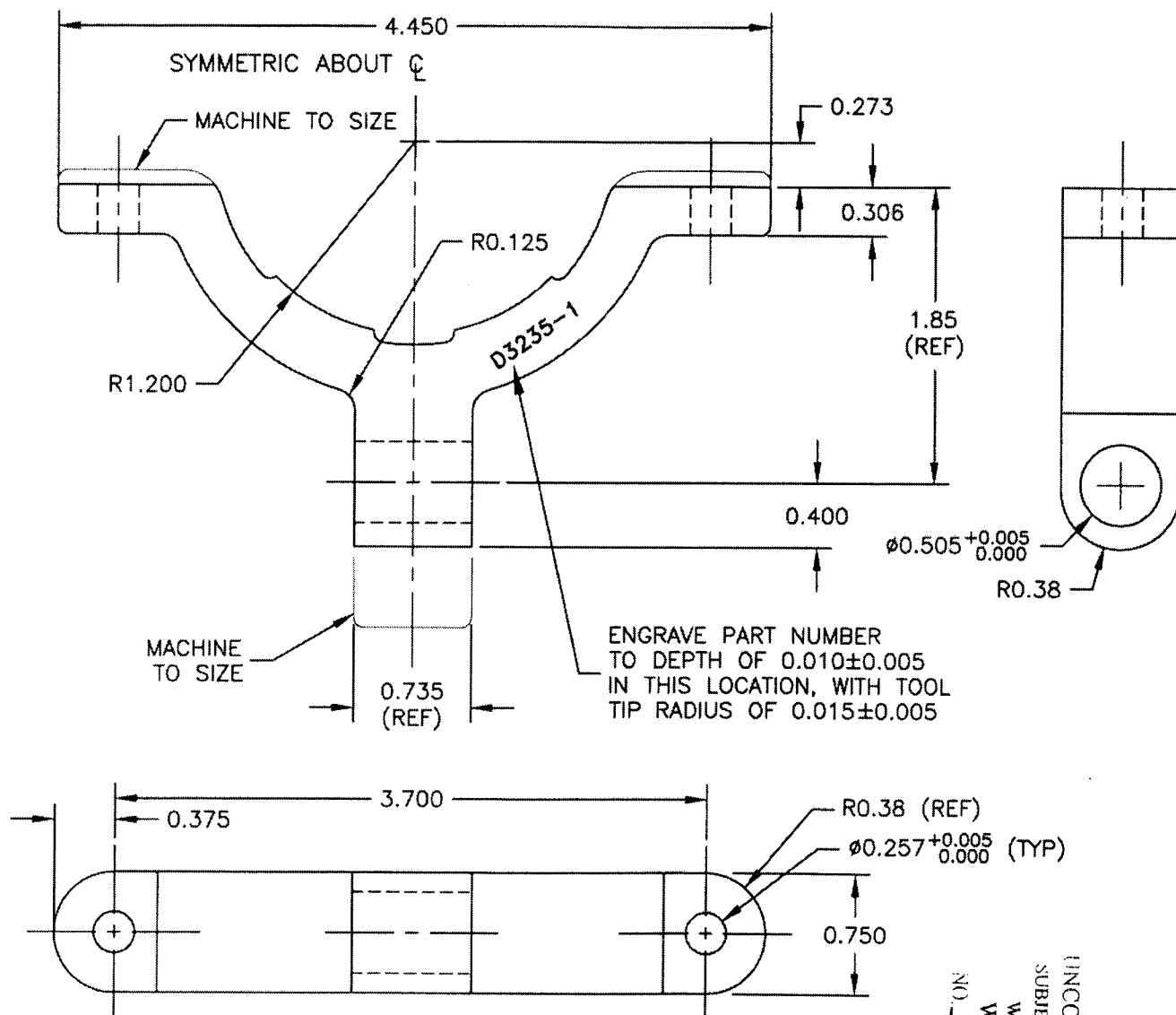
**NOTE:** Date & initial all entries





|                      |                       |   |                        |
|----------------------|-----------------------|---|------------------------|
| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>CP</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>##</i> | APPROVED<br><i>##</i> | DRAWING NO.<br>D3235                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br>04.03.02     |                       | TITLE<br>MOUNTING LUG                             | SCALE<br>1:1           |
| A                    | 04.03.02              | NEW ISSUE   |                        |

RELEASED  
040405



**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 1888

83053 MCO  
12/09/26

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 18699  
**Date:** May 29, 2012  
**Page:** 1

|  |   |
|--|---|
| <b>Sold to:</b><br><br><b>Dart Aerospace Ltd.</b><br>Att. Linda Lacelle<br>1270 Aberdeen Street<br>Hawkesbury, Ontario K6A 1K7 | <b>Ship to:</b><br><br>Dart Aerospace Ltd.<br>Att. Linda Lacelle<br>1270 Aberdeen Street<br>Hawkesbury, Ontario K6A 1K7 |
| <b>Order No.:</b> 16853  | <b>Sold By:</b> Dewar, Eric   |
| <b>Shipped By:</b> your truck  | <b>Ship Date:</b>   |

| Description  | Unit | Ordered quantity          | Shipped quantity | Backorder quantity |
|--|------|---------------------------|------------------|--------------------|
| D3235-1 Mounting Lug   | Each | 100                       | 100              |                    |
| The delivered goods must be inspected upon receipt to confirm compliance.<br>Should there be discrepancies please notify METEC within 30 days of delivery.<br>The goods are otherwise deemed accepted. |      |                           |                  |                    |
| Received by _____  |      | Thank you for your order! |                  |                    |



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0  
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

| <u>QUANTITY</u> | <u>PART NUMBER</u> | <u>PART NAME</u> | <u>P.O. NUMBER</u> |
|-----------------|--------------------|------------------|--------------------|
| 100             | D3235-1            | Lug              | 16853              |

MATERIAL: supplied by DART B81577

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, May 29, 2012